

Atty's 21543

Pat. App. 09/603,528

CLAIM AMENDMENT

1           1. (currently amended) A method of making a sample tube  
2 ~~especially to receive a biological sample~~, comprising the steps of:

3           injection molding an intermediate tube in one piece with  
4 a cylindrical wall and ~~an~~ a conical intermediate bottom spaced  
5 between ends thereof, integral with said wall and having an apex  
6 turned toward an end of said intermediate tube thereby forming a  
7 well adapted to receive a biological sample; and

8           heating said an end of said intermediate tube and press-  
9 ing edges of said end inwardly toward an axis of said intermediate  
10 tube to thermally reform said tube and provide at least a partial  
11 bottom end for the sample tube; and

12           rounding the bottom end of the sample tube outside an  
13 injection mold in which said tube is formed by pressing a heated  
14 stamp thereagainst to cause said bottom end of said sample tube to  
15 be shaped to a concavity of a concave recess of said stamp and to  
16 be only partially closed by said stamp whereby said bottom end is  
17 self-orienting upon insertion of the sample tube into a stand to  
18 permit removal of the biological sample from said well by a pi-  
19 pette.

2. - 4. (canceled)

Atty's 21543

Pat. App. 09/603,528

1           5. (currently amended) The method defined in claim 4 1  
2 wherein said stamp heats said intermediate tube to a temperature at  
3 least equal to the flow temperature of a thermoplastic synthetic  
4 resin constituting said intermediate tube.

6. - 9. (canceled)